

Work Order ID 76733

76733

Page 1

Item ID: D205-634-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube

Stop ***NS2***

Start Date: 21/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 07/12/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: M.L.5

Date: 11/11/21

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2580-041

Rev.E

100

0.00

100

DOCUMENT CONTROL


DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

N/A 

110

0.00

110

BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio 16

JW 11-11-30

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

mo 11-11-30

W/O: 76733		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D205-634-041 PAR #: N/A Fault Category: Skid-tube NCR: Yes No QDA: initial Date: 11/12/12
 Resolution: use as-is Disposition: use as-is QA: N/C Closed: OK Date: 11/12/12

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11.12.01	110	Tube front bend is too short. Height is OK but length from saddle hole is 30.38 (dwg = 32±1)	QP 11.12.01 PS/042	Acceptable	N/A	BE 11-12-04	QP 11.12.01 PS/042	S unclasp
11.12.02	110	AFT BEND IS 1.6" HIGH	QP 11.12.02 PS/042	ACCEPTABLE	N/A	BE 11-12-04	QP 11.12.02 PS/042	S unclasp

NOTE: Date & initial all entries

Work Order ID 76733

76733

Page 2

November-21-11 9:25:37 AM

Item ID: D205-634-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube

Stop ***NS2***

Start Date: 21/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 07/12/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
120									
Skidtubes	Memo	0.00							
Skidtubes	1- Deburr ends and remove bending marks								
	2- Prepare tube for welding as per QSI 004								
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control									

SAD 11-12-01

(1)

1 0 2E11-12-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 76733***76733***

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November-21-11 9:25:37 AM

Item ID: D205-634-041 Accept ***N900040100*** Setup Start ***NS1***
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Item Name: Replacement Skidtube
Start Date: 21/11/2011 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 07/12/2011 Req'd Qty: 1.00 ***1*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

0.00

140

Skidtubes

Skidtubes

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R Aluminum Rod *M118735*

BE 11-12-04

2-Grind welds on step as per Dwg D2580

3-Weld spacers as per dwg D2580

*AIR M118735**BE 11-12-04*

3- *** N/A**** Insert D4202-1 spacer, swage as per QSI002 and trim/ grind
flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2
x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimension.

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",
adjust stopper not to hit web. Debur

DL 11/12/05

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

*+G bore**[Signature]**11-12-5*

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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 Start Date: 21/11/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 07/12/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
180 Powdercoat									
Powder Coating	Memo								
	START TIME: 12:00	0.00							
	OVEN TEMPERATURE: 320 OF								
	FINISH TIME: 12:30								
190	QC3- Inspect Part Finish	0.00							
190 QC									
Quality Control	Memo								

1X/M-11/12/06

1 OK 11-12-6.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 21/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 07/12/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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200

0.00

200

HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of
Sikaflex on insert holes before installing wearplates
A/R Sikaflex-291 119443
Sikaflex expire date: 12-1

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as
per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with
Sikaflex. Clean excess adhesive
A/R Sikaflex-291 119443
Sikaflex expire date: 12-1

5-Wing Walls as per Dwg D2580 and QSI 005 4.4
Batch: 118988

1 132 11-12-6-

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 76733

76733

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Item ID: D205-634-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Replacement Skidtube
 Start Date: 21/11/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 07/12/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 *210* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024	0.00 0.00							
220 *220* Packaging Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPPD205-634-041 Location: _____ PPP Rev: _____ PPP 76412	0.00 0.00							
230 *230* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

Signature

11/12/8

msf 11-12-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

November-21-11 9:25:42 AM

Page 1

Work Order ID: 76733

76733

Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 21/11/2011

Required Date: 07/12/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30
KJ IPP Rev P 10.02.19
per PAR09-043 EC verified by:DD
IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q
10.12.01 as per chg003 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4202-1		Manufactured	No			140	Each	492.0000	20	20			
---------	--	--------------	----	--	--	-----	------	----------	----	----	--	--	--

D4202-1

Spacer

**

Location	Loc Qty	Loc Code
LG002	492	
66929	106	
67129	196	
67308	1	
67430	140	
72639	49	

BE11-12-04
B 77040 ~20

D2580-1		Manufactured	No			110	Each	13.0000	1	1			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D2580-1

205 Skidtube bent detail

**

Location	Loc Qty	Loc Code
LG 76571	13	
72965	1	
76174	2	
76175	2	
76423	2	
76424	2	
76510	2	
76511	2	

① mo 11-11-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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November-21-11 9:25:42 AM

Work Order ID: 76733

76733

Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 21/11/2011

Required Date: 07/12/2011

Start Qty: 1.00

Required Qty: 1.00

D2576-3 Manufactured No

140

Each

109.0000

1

1

D2576-3

Step (maching detail)

BE 11-12-04

Location

Loc Qty

Loc Code

LG

109

66156

9

70883

50

74136

50

D2855 Manufactured No

200

Each

56.0000

1

1

D2855

Cap

BR 11-12-6

Location

Loc Qty

Loc Code

FP002

50

73347 ✓

50

FP007

6

65519

2

65569

4

AN3-5A Purchased No

200

Each

904.0000

2

2

AN3-5A

Bolt

BR 11-12-6

Location

Loc Qty

Loc Code

ST350

904

115371

46

117423 ✓

358

118626

300

119355

200

AN960JD10L **NASI149D0332J* Purchased No

200

Each

0.0000

2

2

***AN960.ID10I ***

Washer

119389

2 BR 11-12-6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Page 3

Work Order ID: 76733

76733

Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 21/11/2011

Required Date: 07/12/2011

Start Qty: 1.00

Required Qty: 1.00

ALS7-1032-130

Purchased

No

200

Each

1,705.000

50

50

AI S7-1032-130

Insert

**

BL 11-12-6.

Location

Loc Qty

Loc Code

ST281

113

117717

27

118966

86

ST282

1592

119530 ✓

1592

50.

AN3C4A

Purchased

No

200

Each

1,925.000

50

50

AN3C4A

BOLT

**

BL 11-12-6.

Location

Loc Qty

Loc Code

ST350

1925

117313

2

117688

5

117872

10

118112

16

118451

2

118838 ✓

962

119328 ✓

928

50.

AN960C10L

* NAS1149C03320 R

Purchased

No

200

Each

0.0000

50

50

***AN960C10I ***

washer

119736.

**

50. BL 11-12-6.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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November-21-11 9:25:42 AM

Work Order ID: 76733

76733

Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 21/11/2011

Required Date: 07/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3566-13 Manufactured No

200 Each 26.0000 1 1

D3566-13

Gasket

**

BL 11-12-6

Location Loc Qty Loc Code

FP	25	
73322 ✓	25	1
FP014	1	
68341	1	

D3566-5 Manufactured No

200 Each 26.0000 1 1

D3566-5

Gasket

**

BL 11-12-6

Location Loc Qty Loc Code

FP002	26	
74387	4	
75069 ✓	22	1

D3566-1 Manufactured No

200 Each 25.0000 2 2

D3566-1

Gasket

**

BL 11-12-6

Location Loc Qty Loc Code

FP002	23	
74518 ✓	23	2
FP015	2	
68924	2	

D3564-11 Manufactured No

200 Each 17.0000 1 1

D3564-11

Wearshoe

**

BL 11-12-6

Location Loc Qty Loc Code

FP001	16	
74705 ✓	16	1
FP019	1	
73146	1	

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 21/11/2011

Required Date: 07/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3564-13

Manufactured No

200 Each

13.0000 1 1

D3564-13

Wearshoe

**

BR 11-12-6

Location

Loc Qty

Loc Code

FP001

12

73323

12

FP017

1

71594

1

D3564-9

Manufactured No

200 Each

26.0000 1 1

D3564-9

Wearshoe

**

BR 11-12-6

Location

Loc Qty

Loc Code

FP

7

73345

7

FP001

14

75071

14

FP019

5

67590

4

69943

1

D3564-5

Manufactured No

200 Each

18.0000 1 1

D3564-5

Wearshoe

**

BR 11-12-6

Location

Loc Qty

Loc Code

FG

2

34806

2

FP001

12

74543

12

FP019

4

73330

4

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 21/11/2011

Required Date: 07/12/2011

Start Qty: 1.00

Required Qty: 1.00

D2594-3 Manufactured No

200 Each 672.0000 16 16

D2594-3

O-Ring, 205 Skidtube

**

PR 11-12-0

Location

Loc Qty

Loc Code

FP

474

65518

41

66952 ✓

135

73490

298

FP004

198

73490 ✓

198

27
9

D2594-1 Manufactured No

200 Each 288.0000 16 16

D2594-1

Plug, 205 Skidtube

**

PR 11-12-0

Location

Loc Qty

Loc Code

FP

288

73401

288

74442

16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

LIST OF MATERIALS					PART NUMBER	DESCRIPTION
ITEM	QTY -041	QTY -045	QTY -047			
1	X				D2580-041	SKIDTUBE ASSEMBLY
2		X			D2580-045	SKIDTUBE ASSEMBLY
3			X		D2580-047	SKIDTUBE ASSEMBLY
4	1	1	1		D2500-1-190	EXTRUSION
5				16	D2570	BUSHING
6	1	1	1		D2576-3	STEP
7	20	24	25		D2579	SPACER
8	16	16	8		D2594-1	PLUG
9	16	16	8		D2594-3	O-RING
10	1	1	1		D2596	205 WEB
11	1	1	1		D2855	AFT CAP
12	1	1			D3564-5	WEARSHOE
13	1	1			D3564-9	WEARSHOE
14	1	1			D3564-11	WEARSHOE
15	1	1			D3564-13	WEARSHOE
16	2	2			D3566-1	GASKET
17	1	1			D3566-5	GASKET
18	1	1			D3566-13	GASKET
19			1		D4406-041	WEARPLATE ASSEMBLY
20			1		D4406-043	WEARPLATE ASSEMBLY
21	50	50			ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
22	50	50			AN3C4A	BOLT
23	2	2	2		AN3-5A	BOLT
24				8	AN4-45A	BOLT
25	50	50			NAS1149C0332R	WASHER (AN960C10L)
26	2	2	2		NAS1149D0332J	WASHER (AN960JD10L)
27				8	MS21042-4	NUT (OR MS21042L4)

GENERAL NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY (-041/-047) GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
POWDER COAT ASSEMBLY (-045) GREEN SANDEX (REF 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2580-041 = 34.5 lbs
D2580-045 = 34.5 lbs
D2580-047 = 37.7 lbs
- 8) WELDING PER DART QSI 004.
- 9) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 10) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 11) USE DART DRILL TEMPLATE DT8217 & DT8937 ONLY FOR D2580-041/-045 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTIONS B-B AND F-F (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241/-291.
- 12) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES FOR D2580-041/-045 AND 8 PLACES FOR D2580-047)
- 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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WITHOUT NOTICE
WORK ORDER

76733 M.C.J
11/11/21

RELEASED
2011-08-29

E	ADD D2580-047 (ZN C4-7) AND D2580-7 (ZN B3-8). INCLUDED DEO D2580-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DT8217 & DT8937 WAS TD2577-205 (ZN C4-1)	RF	11.06.21
D	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/ 9183	PH	07.04.05
C	REDRAWN, INCLUDED DEO 9094/ 9097	CP	98.08.26
B	AS MANUFACTURED	DS	96.12.02
A	NEW ISSUE	DS	96.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	140	DRAWING NO.	REV. E
MFG. APPR.	140	D2580	SHEET 1 OF 8
APPROVED	140	TITLE	SCALE
DE APPR.	140	205 SKIDTUBE ASSEMBLY	NTS
DATE	11.06.21	<small>COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

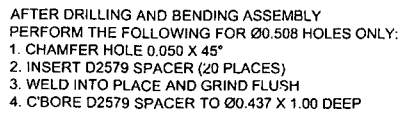
NOTE: Date & initial all entries



C



A

A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

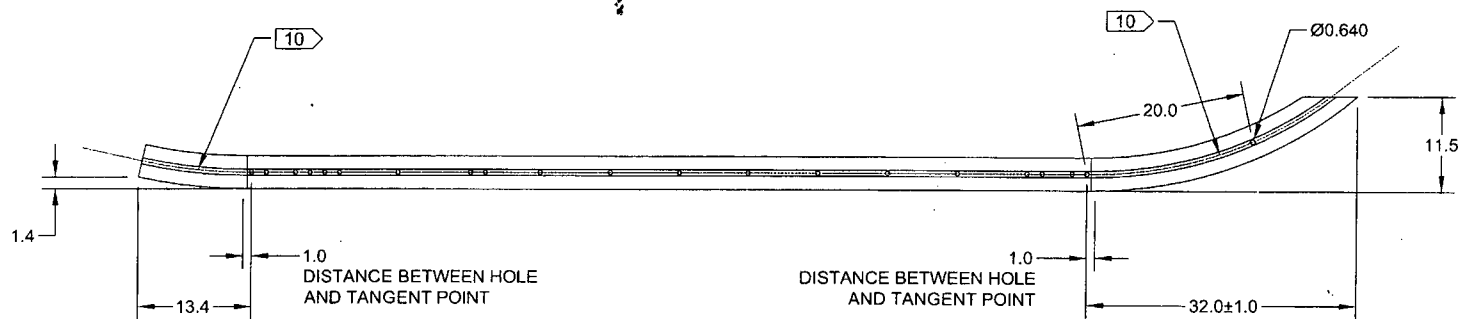
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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D2580-1 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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JW

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MFG. APPR.	10	D2580	SHEET 3 OF 8
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

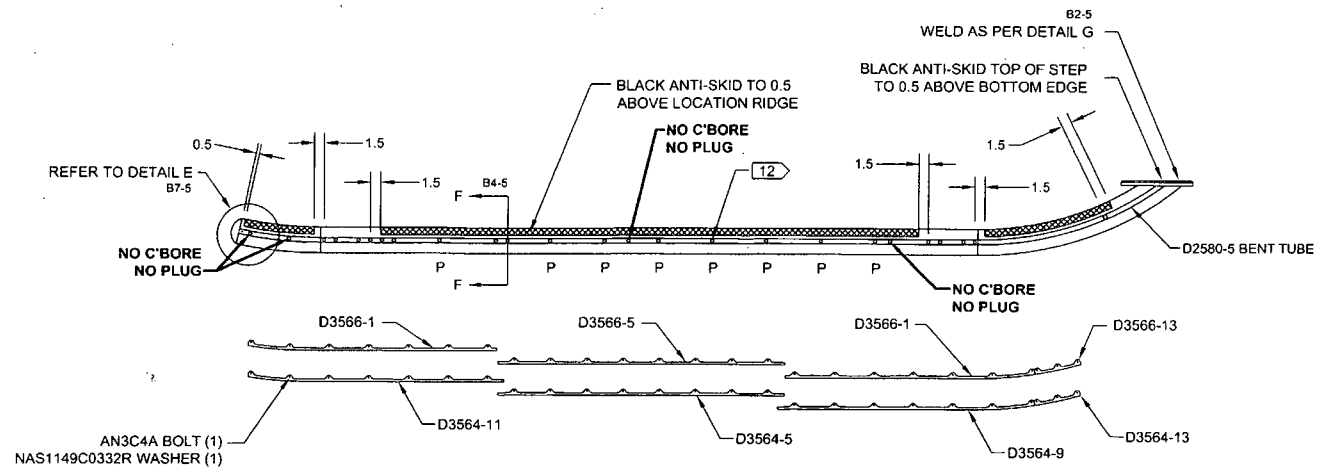
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

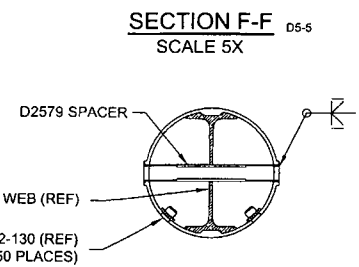
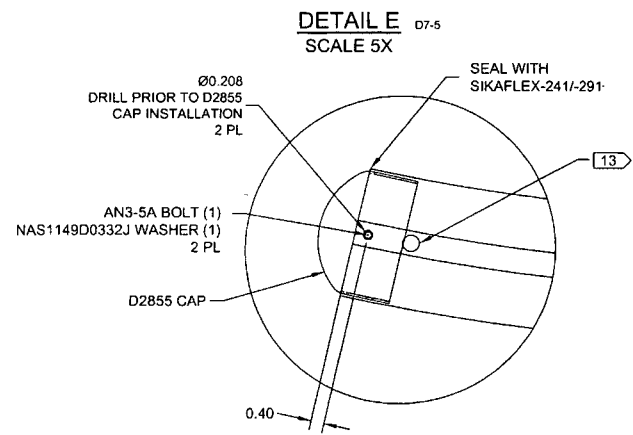
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

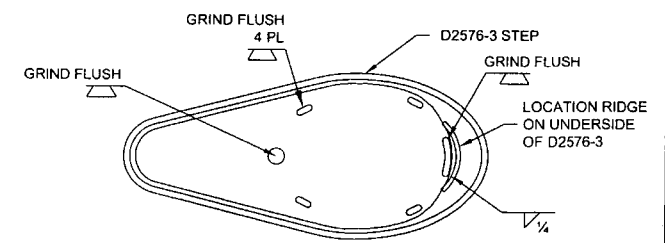
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D2580-045 ASSEMBLY DETAIL



- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
 2. INSERT D2579 SPACER (24 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP



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DESIGN	4	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED	10	DRAWING NO.	REV. E
MFG. APPR.	10	D2580	SHEET 4 OF 8
APPROVED	10	TITLE	SCALE
DE APPR.	10	205 SKIDTUBE ASSEMBLY	NTS
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

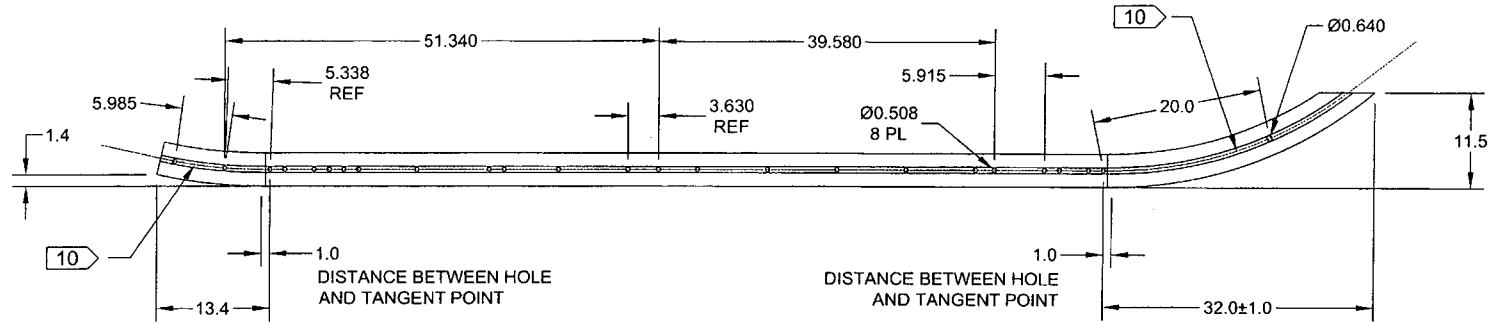
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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D2580-5 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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2011-08-29

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MFG. APPR.	10	D2580	SHEET 5 OF 8
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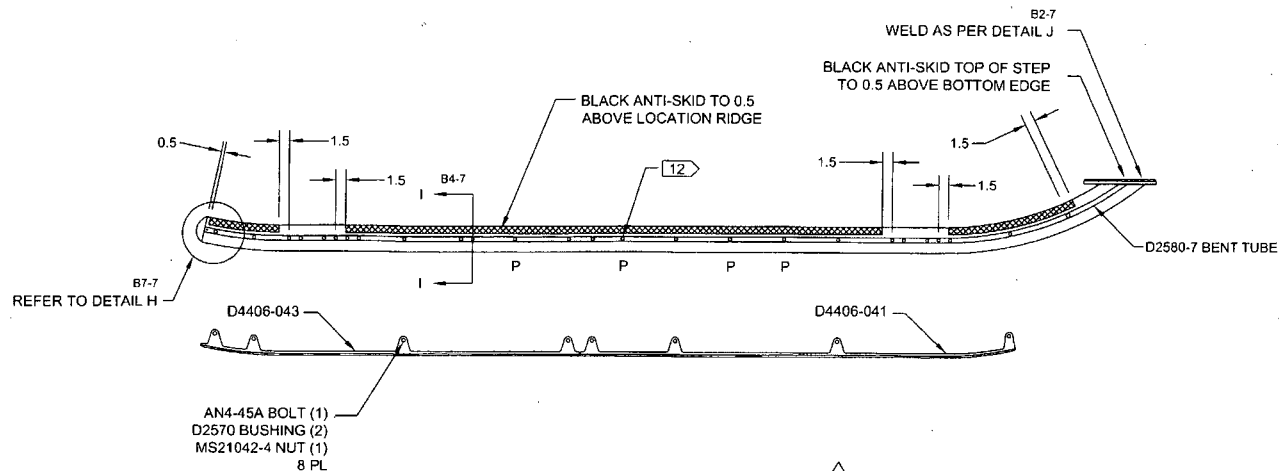
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

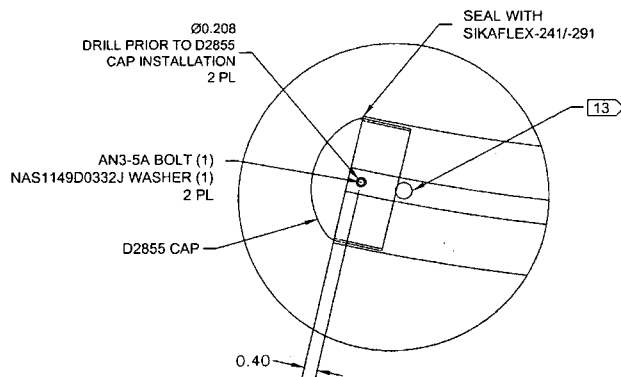
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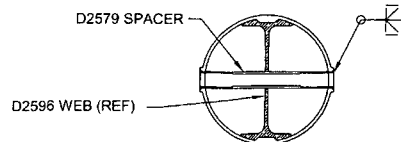


D2580-047 ASSEMBLY DETAIL E

DETAIL H C6-7
SCALE 5X

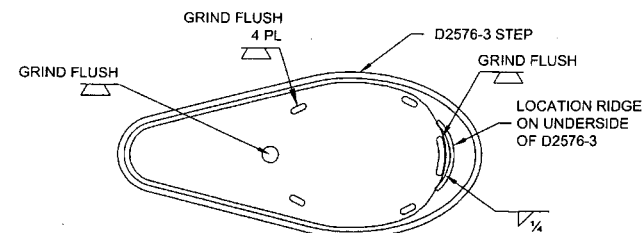


SECTION I-I D5-7
SCALE 5X



- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
 2. INSERT D2579 SPACER (25 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

DETAIL J D3-7
SCALE 5X



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MFG. APPR.	10	D2580	SHEET 6 OF 8
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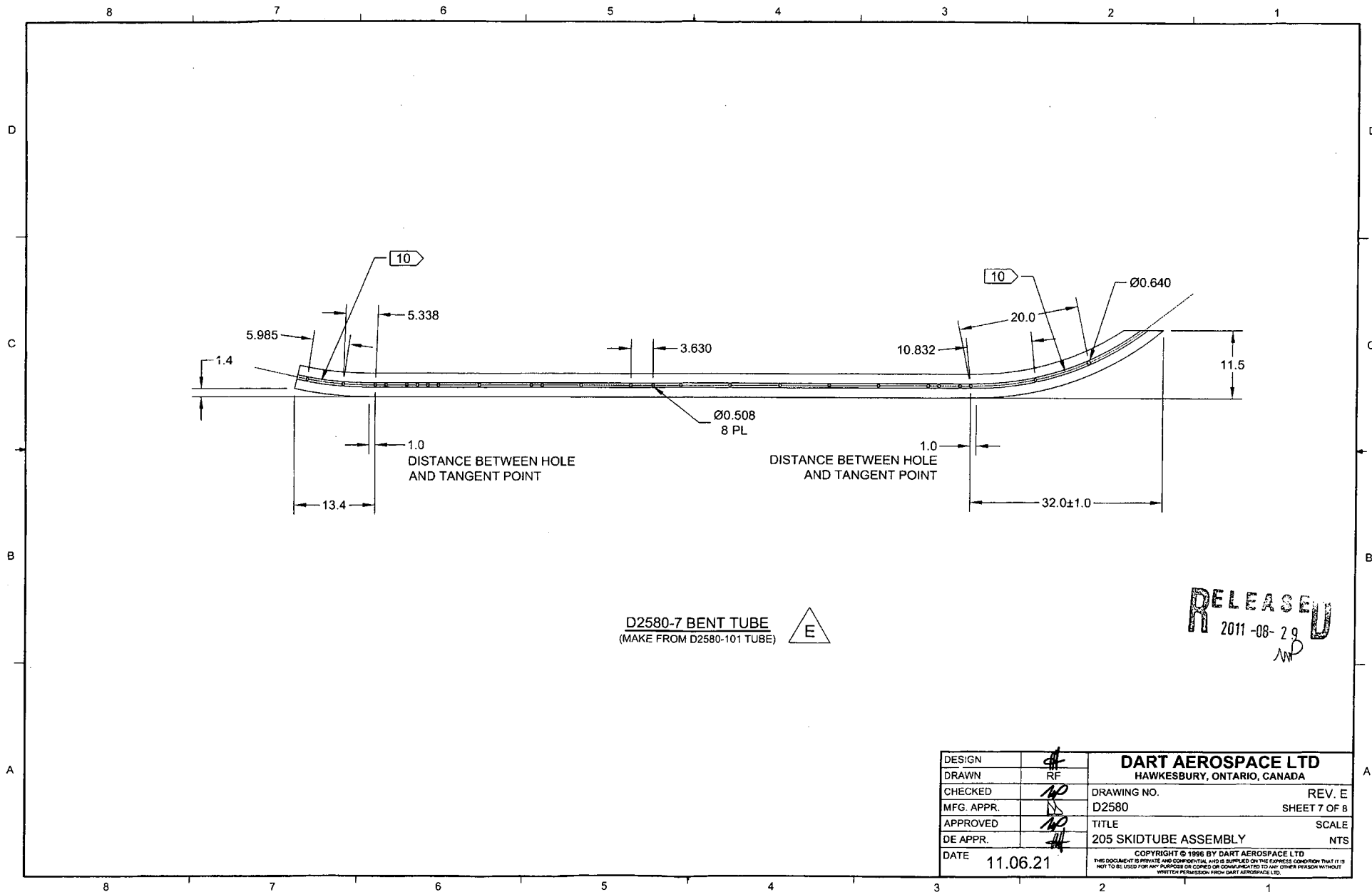
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D2580-7 BENT TUBE
(MAKE FROM D2580-101 TUBE)



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DESIGN	RF	DART AEROSPACE LTD	
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CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	RF	D2580	SHEET 7 OF 8
APPROVED	RF	TITLE	SCALE
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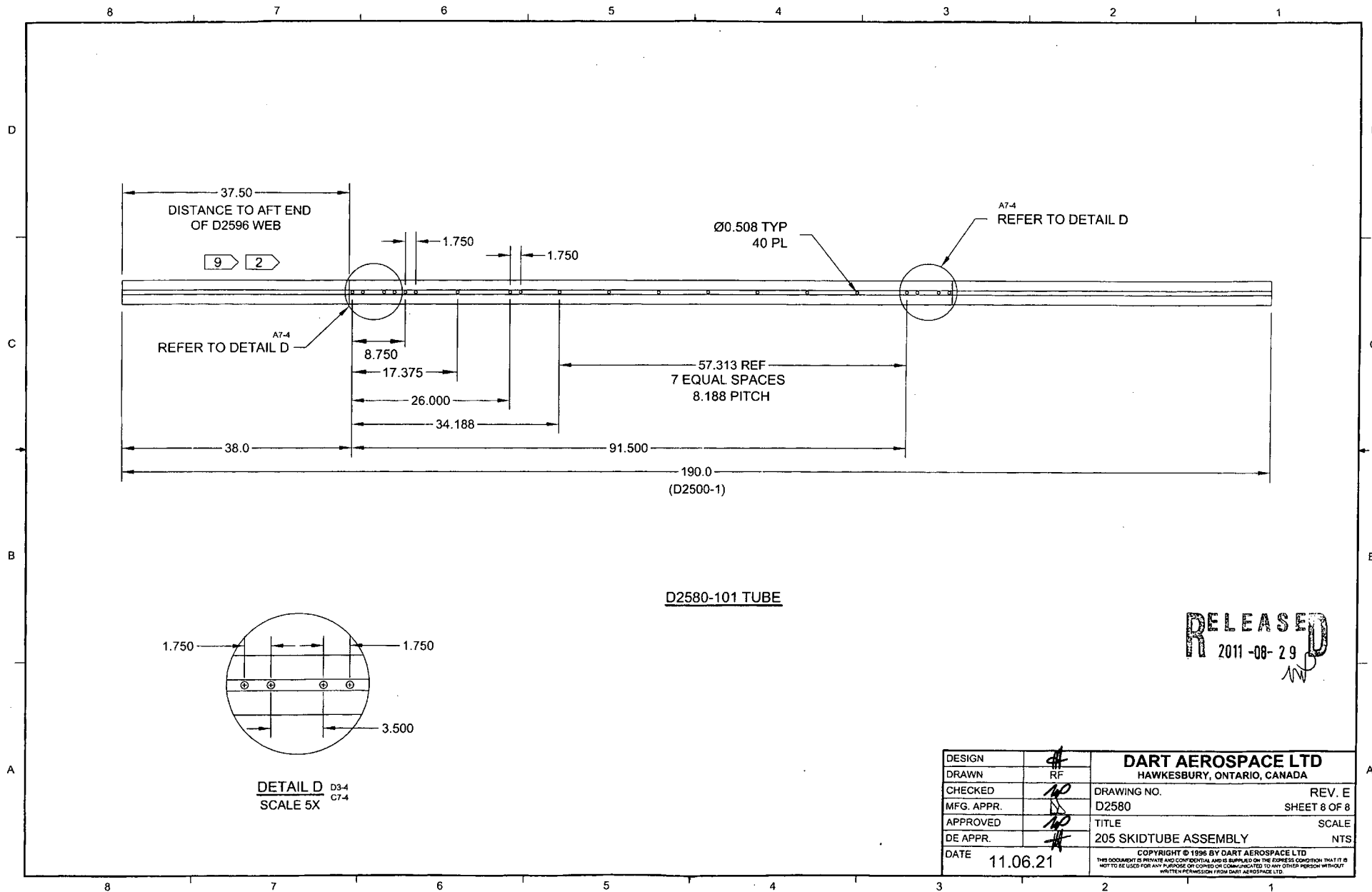
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 275

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 76550
Part number: 205-634-041
Description: SKID Tube
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier David Smith Date of Test Coupon 11.11.22
Welder Barclay Elliot Date of Test Coupon 11.11.22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld